

# Work Order ID 69890

Tuesday, May 24, 2011 10:04:33 AM



Page 1

Item ID: D2012-117

Accept



Setup Start



Revision ID:

Item Name: Clevis

Stop



Start Date: 5/24/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

*P*

Date: 11-05-24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2012-117

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2012

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

304. 063

B11-5-25

39

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-5-25

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/11/12

Count 31

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69890**

Tuesday, May 24, 2011 10:04:33 AM

Page 3



Item ID: D2012-117

Accept



Setup Start



Revision ID:

Stop



Item Name: Clevis

Start Date: 5/24/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/31 *[Signature]*  
MF  
11-05-30

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 24, 2011 10:05:05 AM

Page 1

Work Order ID: 69890

Parent Item: D2012-117

Parent Item Name: Clevis



Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP: C 99.06.16 Re-format, Now Laser Cut DM  
IPP Rev:D Now on WaterJet 07-03-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased		No		100	sf	167.8000	0.0137	0.432632			
304/316 Sheet .063												1811-5-25	

Location

Loc Qty

Loc Code

MAT020

167.8

117275

7.8

117653

160

117653

Po# 13999

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

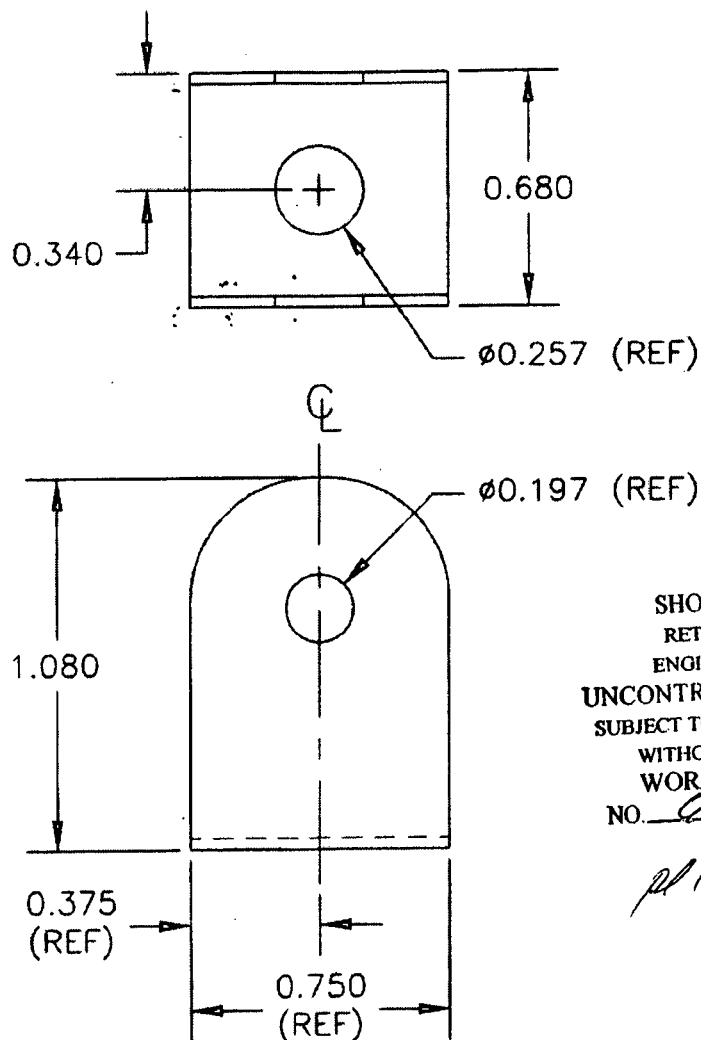
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED 	DRAWING NO. D2012-117	REV. C SHEET 1 OF 2
DATE 99.05.05	TITLE CLEVIS		SCALE 2:1
A	94.10.27	NEW ISSUE	
B	94.10.27	CHANGED HOLE SIZE, WAS D2012-107	
C	99.05.05	ADD FLAT PATTERN	

RELEASED  
94.05.11 KE



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 69890

*2011-05-24*

MATERIAL: AISI 304/316 SS 0.063 THICK  
USE 0.032 BEND RADIUS  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

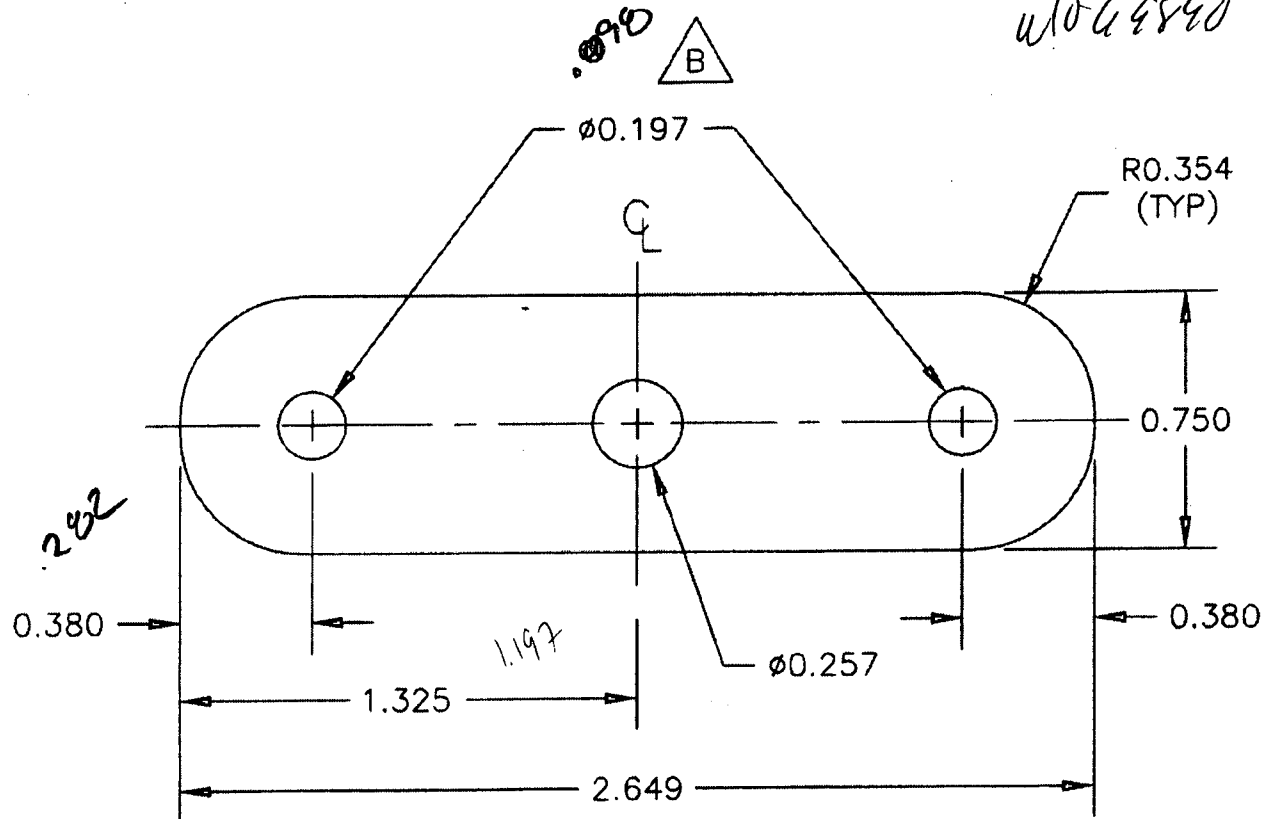
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED <i>[Signature]</i>	DRAWING NO. D2012-117	REV. C SHEET 2 OF 2
DATE 99.05.05	TITLE CLEVIS		SCALE 2:1

RELEASED  
99.05.11 KE



D2012-117 FLAT PATTERN

MATERIAL: AISI 304/316 SS 0.063 THICK  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

# Receiving Report

Date: 11/5/10  
 Supplier: MAGNA

Batch No: M11 7653  
 Dart P/O: 13999

Packing Slip: Yes ☒ No ☐  
 Invoice: Yes ☐ No ☒  
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐  
 Waybill Attached: Yes ☐ No ☒ N/A ☐  
 Shipment Complete: Yes ☒ No ☐ N/A ☐  
 QC6 Inspection ☒ N/A ☐  
 Work Order ☐ N/A ☒

## Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12   

Production/Admin: 11/5/10  
 Date     
 Received/Costing     
 Initial   

Location

# Purchase Order Receipt Listing

Page 1 of 2

Tuesday, May 10, 2011 8:18:48 AM

All amounts are calculated in domestic currency.

All Vendors PO ID PO13999 Receipt Dates from 5/10/2011 to 5/10/2011 All Line Item Types  
All Item ID/GL/WOs All Rec. Employees All Currencies  
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID/Vendor Name VC-MAG002 Magna Stainless											
PO13999	1		M304S16GA	sf	5/9/2011	5/10/2011	160.0000	\$5.66	0.0000	0	\$904.99
CAD	No		304/316 Sheet .063	sf	160.0000	DESJ02		\$904.99	0.0000	0	
			117653								
	2		M304S18GA	sf	5/9/2011	5/10/2011	96.0000	\$4.53	0.0000	0	\$435.00
	No		304/316 .050 Sheet	sf	96.0000	DESJ02		\$435.00	0.0000	0	
			117653								
	3		M6061T6S.040	sf	5/13/2011	5/10/2011	96.0000	\$5.47	0.0000	0	\$525.00
	No		6061-T6 .040 Sheet	sf	96.0000	DESJ02		\$525.00	0.0000	0	
			117653								
	4		M6061T6B0.375X00. f		5/9/2011	5/10/2011	20.0000	\$2.45	0.0000	0	\$49.00
	No		750		24.0000	DESJ02		\$49.00	0.0000	0	
			6061T6 BAR .375 x f								
			.750								
			117653								
	5		M6061T6B0.375X01. f		5/9/2011	5/10/2011	20.0000	\$0.90	0.0000	0	\$18.00
	No		000		20.0000	DESJ02		\$18.00	0.0000	0	
			6061T6 BAR .375 x f								
			1.00								
			117653								
	6		M6061T6B00750X00 f		5/9/2011	5/10/2011	60.0000	\$0.26	0.0000	0	\$15.75
	No		.125		60.0000	DESJ02		\$15.75	0.0000	0	
			6061-T6 Bar .750 x f								
			.125								
			117653								
	7		M6061T6B30000X01 f		5/13/2011	5/10/2011	12.0000	\$30.42	0.0000	0	\$365.00
	No		.500		12.0000	DESJ02		\$365.00	0.0000	0	
			6061-T6 Bar 3.00 x f								
			1.50								
			117653								





# Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3  
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105



## PACKING LIST

Page 1 of 1 I043089

SOLD TO:  
DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY, ON K6A 1K7

SHIP TO:  
DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY, ON K6A 1K7

### SPECIAL INSTRUCTIONS

\*\*\*\*STOCK\*\*\*\*  
1 ITEM INC 145096

Contact: C.LAVOIE

Ship Terms: PREPAID

MTR:Y

Currency		Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS		CHRISTINA ANTONIOU	(613) 632-5200	(613) 632-1053	13999	
Sales Order	Terms		Ship Via	Date Ordered	Date Required	Date Shipped
W047356	NET 30 DAYS		NIR:R-557065-1	05/04/11	05/09/11	05/09/11

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
1		PC	ALUMINUM FLATS AFL 6061 T6 3/8" x 1" x R/L			1
3		PC	AFL 6061 T6 1/8" x 3/4" x R/L	20' 9 LB / 1 PC ✓ L040276	(10173)	1
1		PC	AFL 6061 T6 3/8" x 3/4" x R/L	20' 7 LB / 3 PC ✓ L046875	12241	3
		PC	AFL 6061 T6 3/8" x 3/4" x R/L	20' 7 LB / 1 PC ✓ L050234	(10120123B)	1
5		PC	STAINLESS SHEET SSH 304 2B 16ga x 48" x 96"	420 LB / 5 PC ✓ L049228	(10001262YU)	5
3		PC	SSH 304 2B 18ga x 48" x 96"	201 LB / 3 PC L049679	(10001106TE)	3
SURCHARGE SUR CARBURANT						
<i>Emilio</i>						
Bundles: 1 Skids: 1 Pieces: 1				Approx Weight:		644 LB

Received by: \_\_\_\_\_ Date: \_\_\_\_\_ Signature: \_\_\_\_\_



P12866

C026125

## INSPECTION CERTIFICATE

CUSTOMER: MAGNA STAINLESS INC.(DIV. OF CANADIAN SPECIALTY METALS INC.)

INVOICE NO: SSCAE41101TE9

CREDIT NUMBER: 1700799

CERTIFICATE NO: 100022201

Date: FEB. 22, 2011

DESCRIPTION: STAINLESS STEEL COILED ROLLED SHEETS

Page: 1 of 5

P/L NO.	SIZE	UNIT(PCS)	N.W.(KG)	TYPE/FINISH	HEAT NO.	REFERENCE NO.
1	0.6mm (24ga) X 1219.2mm (48") X 2438.4mm (96")	153	2056	304/ 2B PAPER	10001265YU -100 010652	YERYCA10001A-01A
2	0.7mm (22ga) X 1219.2mm (48") X 2438.4mm (96")	79	1233	304/ 2B PAPER	9911188YU -100 010662	YERYCA10001A-02A
3	0.7mm (22ga) X 1219.2mm (48") X 2438.4mm (96")	79	1233	304/ 2B PAPER	9911188YU -100 010662	YERYCA10001A-03A
4	0.7mm (22ga) X 1219.2mm (48") X 3048mm (120")	84	1643	304/ 2B PAPER	9911188YU -100 010662	YERYCA10001A-04A
5	0.9mm (20ga) X 1219.2mm (48") X 2438.4mm (96")	81	1231	304/ 2B PAPER	9912194YU -100 010669	YERYCA10001A-05A
6	1.2mm (18ga) X 1219.2mm (48") X 2438.4mm (96")	60	1615	304/ 2B PAPER	9910168YU -100 010672	YERYCA10001A-06A
7	1.2mm (18ga) X 1219.2mm (48") X 3048mm (120")	61	2056	304/ 2B PAPER	9910168YU -100 010672	YERYCA10001A-07A
8	1.2mm (18ga) X 1524mm (60") X 3048mm (120")	40	1688	304/ 2B PAPER	10001232YU -100 010721	YERYCA10001A-08A
9	1.5mm (16ga) X 1219.2mm (48") X 2438.4mm (96")	36	1228	304/ 2B PAPER	10001262YU -100 010674	YERYCA10001A-09A
10	1.5mm (16ga) X 1219.2mm (48") X 2438.4mm (96")	36	1228	304/ 2B PAPER	10001262YU -100 010674	YERYCA10001A-10A

## Chemical Composition

## Mechanical Test

P/L NO.	C	Si	Mn	P	S	Ni	Cr	N	Cu	Mo	Y.S.(0.2%) N/mm2	T.S. N/mm2	Elongation %	Hardness HV
1	0.043	0.520	1.230	0.032	0.001	8.030	18.040	0.029	0.320	0.160	303	674	49.0	176.0
2	0.051	0.530	1.170	0.037	0.002	8.080	18.190	0.032	0.190	0.090	280	695	57.0	173.0
3	0.051	0.530	1.170	0.037	0.002	8.080	18.190	0.032	0.190	0.090	280	695	57.0	173.0
4	0.051	0.530	1.170	0.037	0.002	8.080	18.190	0.032	0.190	0.090	280	695	57.0	173.0
5	0.021	0.470	1.540	0.037	0.001	8.080	18.440	0.054	0.060	0.010	323	687	46.0	185.0
6	0.049	0.500	0.980	0.038	0.004	8.020	18.010	0.026	0.540	0.170	285	667	52.0	175.0
7	0.049	0.500	0.980	0.038	0.004	8.020	18.010	0.026	0.540	0.170	285	667	52.0	175.0
8	0.013	0.370	1.430	0.032	0.012	8.030	18.110	0.039	0.360	0.200	278	620	56.0	163.0
9	0.023	0.560	1.310	0.032	0.002	8.030	18.310	0.056	0.060	0.020	323	698	47.0	167.0
10	0.023	0.560	1.310	0.032	0.002	8.030	18.310	0.056	0.060	0.020	323	698	47.0	167.0

Remark: 1. We hereby certify that the products described herein have been manufactured and tested with satisfactory results in accordance with the requirement of the above material specification.

2. As per ASTM A240/480 standard.

3. The material described above has been detected with free irradiation.

YIEH CORPORATION LIMITED

Q.C. MANAGER



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

\*\*\*PO REPRINT\*\*\*

Purchase Order ID PO13999

Purchase Order Date 5/4/2011

PO Print Date 5/4/2011

Page Number 1 of 3

Order From :

VC-MAG002

MAGNA STAINLESS  
5775 RUE KIERAN  
ST LAURENT, QC H4S 0A3  
CA

Contact Name  
Vendor Phone 800 363 6646  
Vendor Fax 514 339 1105  
Vendor Account Nbr

Buyer Chantal Lavoie  
Requisition Nbr  
Tax Resale Nbr 10127-2607  
Terms Net 30  
Currency CAD  
FOB Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAKED**  
CCL116567

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M304S16GA 020	304/316 Sheet .063	5/9/2011 Yes	✓ 160.00 sf	Yours ppd	\$5.6562	\$904.99
		Special Inst:	MATERIAL: AISI 304/316 SS SHEET ANEALD 2B FINISH AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240				
2	M304S18GA 020	304/316 .050 Sheet	5/9/2011 Yes	✓ 96.00 sf	Yours ppd	\$4.5312	\$435.00
		Special Inst:	MATERIAL: AISI 304/316 SS SHEET ANEALD 2B FINISH AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240				
3	M6061T6S.040 021	6061-T6 .040 Sheet	5/13/2011 Yes	✓ 96.00 sf	Yours ppd	\$5.4688	\$525.00
		Special Inst:	MATERIAL: 6061-T6 /T62				

*6/11/10*

5/4/2011